

December-17-13 9:16:20 AM

Page 1

Item ID:	D3296-3	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:	B 1 1 0 1 4 9					
Item Name:	Door Panel				Stop	*NS2*
Start Date:	12/17/13	Start Qty: 6.00	*6*	Cust Item ID:		
Required Date:	12/17/13	Req'd Qty: 6.00	*6*	Customer:		
Reference:						

Approvals: **Process Plan:** MLJ **Date:** 13-12-18 **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

Work Order ID 110149

110149

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Item ID: D3296-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Panel
 Start Date: 12/17/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 3-89 0.00 14/2/11				10			
130 *130* Small Fab Small Fab	Small Fab Memo Debur	0.00 0.00			DAS 30 9-89				14/02/12
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	76	14/2-12	

Work Order ID 110149

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110149

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Item ID: D3296-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Panel
 Start Date: 12/17/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00				10			
Quality Control									
160	Identify as per dwg & Stock Location: <u>51237</u>	0.00							
160									
Packaging	Memo	0.00				10			DAS 33 14-62-12 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

[Signature] 14-02-12

Picklist Print

December-17-13 9:16:20 AM

Work Order ID: 110149

Parent Item: D3296-3

Parent Item Name: Door Panel

Start Date: 12/17/13

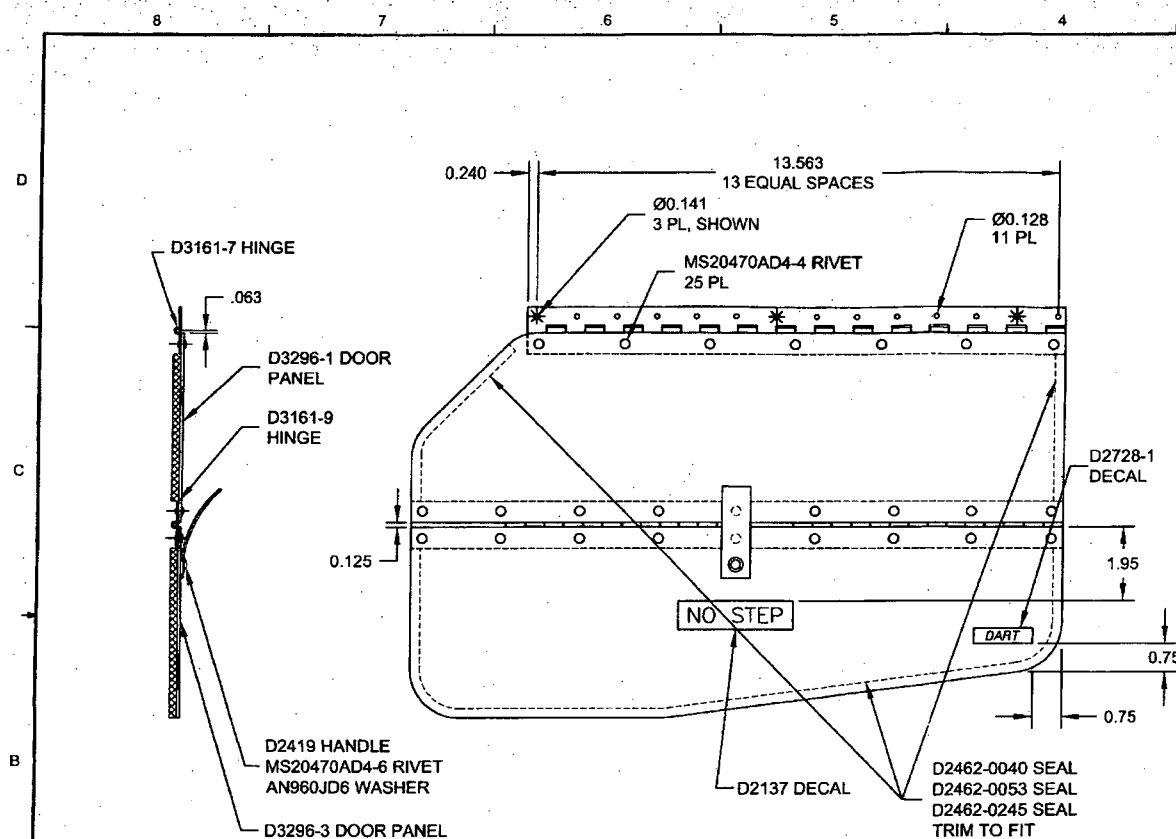
Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	252.7489	0.6532	4.1254734	5.0	Jm14-02-11	
2024-T3 .063 sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		252.7489							
				119916		0.2							
				121197		21.34							
				123096		11.4							
				123654		11.64							
				123701		16.1039							
				125341		87.94							
				125636		104.125				125636			



D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL: D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

110149 MLJ
13-12-18

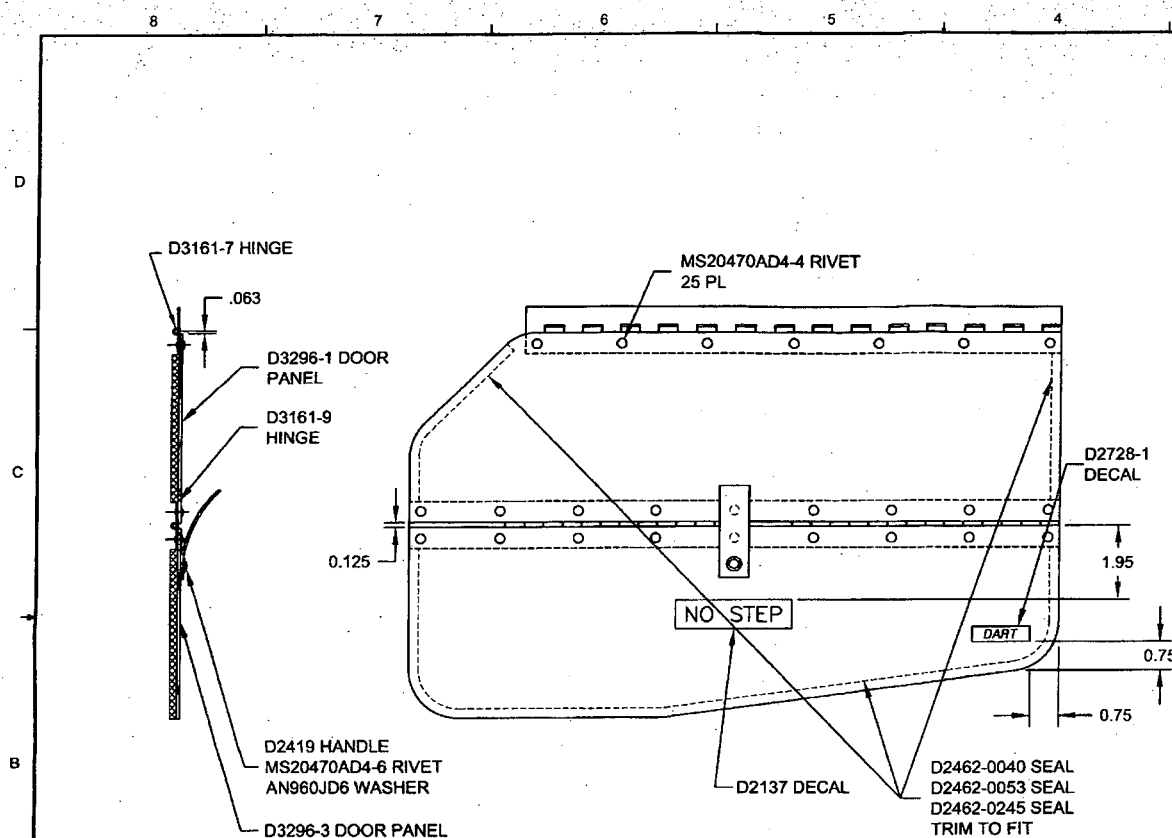
RELEASED
2012-11-21

B	ADD D3296-041B. REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3296 SHEET 1 OF 3
TITLE SCALE
DOOR ASSEMBLY NTS

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D3296-041B DOOR ASSEMBLY, BLANK

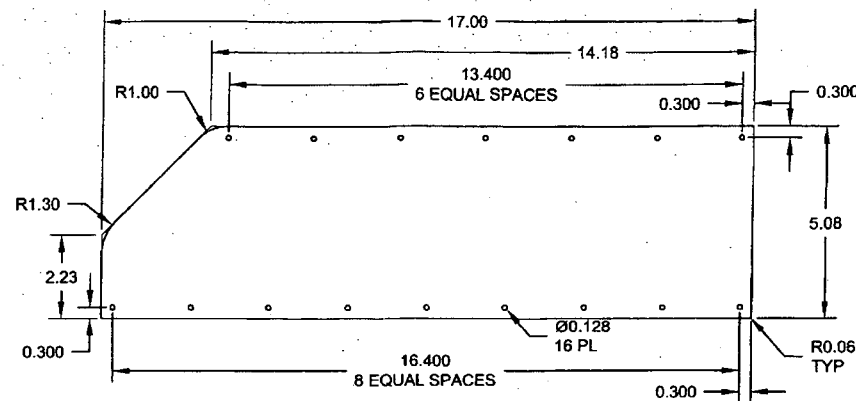
D3296-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

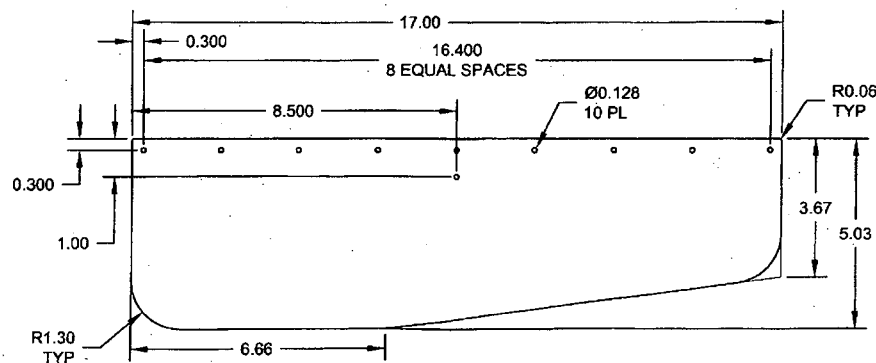
QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

RELEASED
2012-11-21
WFO

DESIGN	97	DART AEROSPACE LTD	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D3296	SHEET 2 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	DOOR ASSEMBLY	NTS
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D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

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2012-11-21
WMO

D3296-1/3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	44	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO.	REV. B
MFG. APPR.	W	D3296	SHEET 3 OF 3
APPROVED	W	TITLE	SCALE
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